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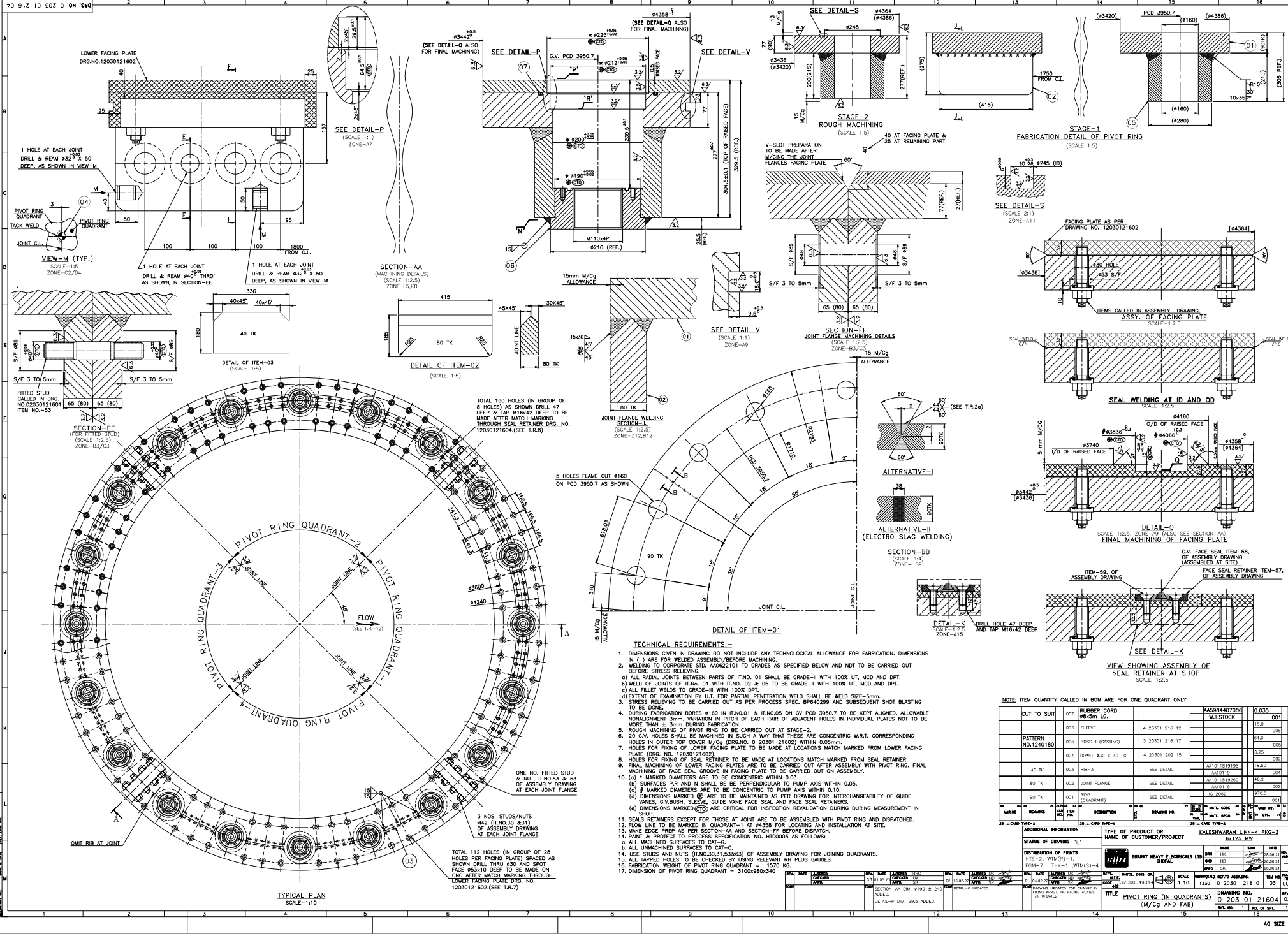

TECHNICAL REQUIREMENTS:–

1. DIMENSIONS GIVEN IN DRAWING DO NOT INCLUDE ANY TECHNOLOGICAL ALLOWANCE FOR FABRICATION. DIMENSIONS IN ( ) ARE FOR WELDED ASSEMBLY/BEFORE MACHINING.
2. WELDING TO CORPORATE STD. AA0622101 TO GRADES AS SPECIFIED BELOW AND NDT TO BE CARRIED OUT BEFORE STRESS RELIEVING.
   a) ALL RADIAL JOINTS BETWEEN PARTS OF IT.NO. 01 SHALL BE GRADE–II WITH 100% UT, MCD AND DPT.
   b) WELD OF JOINTS OF IT.No. 01 WITH IT.NO. 02 & 05 TO BE GRADE–II WITH 100% UT, MCD AND DPT.
   c) ALL FILLET WELDS TO GRADE–III WITH 100% DPT.
   d) EXTENT OF EXAMINATION BY U.T. FOR PARTIAL PENETRATION WELD SHALL BE WELD SIZE–5mm.
3. STRESS RELIEVING TO BE CARRIED OUT AS PER PROCESS SPEC. BP640299 AND SUBSEQUENT SHOT BLASTING TO BE DONE.
4. DURING FABRICATION BORES ø160 IN IT.NO.01 & IT.NO.05 ON GV PCD 3950.7 TO BE KEPT ALIGNED. ALLOWABLE NONALIGNMENT 3mm. VARIATION IN PITCH OF EACH PAIR OF ADJACENT HOLES IN INDIVIDUAL PLATES NOT TO BE MORE THAN ± 3mm DURING FABRICATION.
5. ROUGH MACHINING OF PIVOT RING TO BE CARRIED OUT AT STAGE–2.
6. 20 G.V. HOLES SHALL BE MACHINED IN SUCH A WAY THAT THESE ARE CONCENTRIC W.R.T. CORRESPONDING HOLES IN OUTER TOP COVER M/Cg (DRG.NO. 0 20301 21602) WITHIN 0.05mm.
7. HOLES FOR FIXING OF LOWER FACING PLATE TO BE MADE AT LOCATIONS MATCH MARKED FROM LOWER FACING PLATE (DRG. NO. 120301216O2).
8. HOLES FOR FIXING OF SEAL RETAINER TO BE MADE AT LOCATIONS MATCH MARKED FROM SEAL RETAINER.
9. FINAL MACHINING OF LOWER FACING PLATES ARE TO BE CARRIED OUT AFTER ASSEMBLY WITH PIVOT RING. FINAL MACHINING OF FACE SEAL GROOVE IN FACING PLATE TO BE CARRIED OUT ON ASSEMBLY.
10. (a) * MARKED DIAMETERS ARE TO BE CONCENTRIC WITHIN 0.03.
    (b) SURFACES P,R AND N SHALL BE BE PERPENDICULAR TO PUMP AXIS WITHIN 0.05.
    (c) # MARKED DIAMETERS ARE TO BE CONCENTRIC TO PUMP AXIS WITHIN 0.10.
    (d) DIMENSIONS MARKED Ⓜ ARE TO BE MAINTAINED AS PER DRAWING FOR INTERCHANGEABILITY OF GUIDE VANES, G.V.BUSH, SLEEVE, GUIDE VANE FACE SEAL AND FACE SEAL RETAINERS.
    (e) DIMENSIONS MARKED (CTQ) ARE CRITICAL FOR INSPECTION REVALIDATION DURING DURING MEASUREMENT IN SHOP.
11. SEALS RETAINERS EXCEPT FOR THOSE AT JOINT ARE TO BE ASSEMBLED WITH PIVOT RING AND DISPATCHED.
12. FLOW LINE TO BE MARKED IN QUADRANT–1 AT ø4358 FOR LOCATING AND INSTALLATION AT SITE.
13. MAKE EDGE PREP AS PER SECTION–AA AND SECTION–FF BEFORE DISPATCH.
14. PAINT & PROTECT TO PROCESS SPECIFICATION NO. HT00005 AS FOLLOWS:
    a. ALL MACHINED SURFACES TO CAT–G.
    b. ALL UNMACHINED SURFACES TO CAT–C.
15. USE STUDS AND NUTS (IT.NO.30,31,53&63) OF ASSEMBLY DRAWING FOR JOINING QUADRANTS.
16. ALL TAPPED HOLES TO BE CHECKED BY USING RELEVANT RH PLUG GAUGES.
17. FABRICATION WEIGHT OF PIVOT RING QUADRANT = 1570 KG.
18. DIMENSION OF PIVOT RING QUADRANT = 3100x980x340

NOTE: ITEM QUANTITY CALLED IN BOM ARE FOR ONE QUADRANT ONLY.

	CUT TO SUIT	007	RUBBER CORD ø8x5m LG.			AA5984407086 W.T.STOCK	0.035	001
		006	SLEEVE	4	20301 216 12		15.0	005
	PATTERN NO.1240180	005	BOSS–I (CASTING)	3	20301 216 17		64.0	004
		004	DOWEL ø32 X 40 LG.	4	20301 202 15		0.25	002
	40 TK	003	RIB–3		SEE DETAIL	AA1011819198 AA10119	18.50	004
	80 TK	002	JOINT FLANGE		SEE DETAIL	AA1011819260 AA10119	48.2	002
	90 TK	001	RING (QUADRANT)		SEE DETAIL	IS 2062	970.0	001

VAR.DO	REMARKS	MAT ITEM NO.	DESCRIPTION	SEC.	DRAWING NO.	MATL. CODE	UNIT WT.	ITEM NO.
20 — CARD TYPE–3			20 — CARD TYPE–1			20 — CARD TYPE–2		

ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	KALESHWARAM LINK–4 PKG–2 6x125 MW
STATUS OF DRAWING 'U'		BHARAT HEAVY ELECTRICALS LTD. BHOPAL	DRN UK 28.06.21; CKD ND 28.06.21; APPD SK 28.06.21
DISTRIBUTION OF PRINTS HTE–2, WTM(P)–1, FGM–7, THK–1 ,WTM(S)–4		DEPT. M.E.E. CODE 320000490114	SCALE 1:10 UNTOL. DIMS. OR. ±0.5 TOL. ON ANGLES ±1° REF.TO ASSY.DRG. 1330
			ITEM NO. 03 NO.OF ITEM 007
			DRAWING NO. 0 203 01 216 04 REV. 03
			SHT. NO. 1 NO. OF SHT. 1

REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.
ZONE			03	01.05.21	RTC UK SK	ZONE			04	16.02.22	UK ND SK
			ZONE		SECTION–AA DIM. ø190 & 240 ADDED. DETAIL–P DIM. 29.5 ADDED.				ZONE		DETAIL–K UPDATED.
01	04.02.22	UK ND SK									
ZONE		DRAWING UPDATED FOR CHANGE IN FITTING ASPECT OF FACING PLATES. T.R. UPDATED									

A0 SIZE